



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4842-3

Job Sheet 178085



Part No: D4842-3

Job Qty: 6 ea

POSITIVE RECALL

Part Name: Lower Cutter Body, LH

EFFECTIVE 18-09-10 AUTH PD



RELEASED PD DATE 19-04-2

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 7/16/18

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SLH*

Description:

Note: URF 16-692 DWG REV B U/R SHEET 3 IPP REV: A NEW ISSUE JFS 13/04/30 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		7/16/18	0.00	0.00	Start Up Machining-3		<i>Kt 2018-09-10</i>
100	Bandsaw	6 pcs		7/16/18	0.00	0.54	Bandsaw1		<i>Kt 2018-09-10</i>
110	CNC Vertical Machining	6 pcs		7/16/18	0.54	7.50	HAAS1-5		<i>Kt 2018-09-10</i>
120	QC	6 pcs		7/16/18	0.00	0.00	QC2 Machining-3		<i>Kt 2018-09-10</i>
130	QC	6 pcs		7/16/18	0.00	0.00	QC8 Machining-3		<i>SL 18-9-11</i>
140	Outsource	6 pcs		7/16/18			ATG001-VC		<i>CS 18-9-11</i>
150	Packaging	6 pcs		7/16/18	0.00	0.00	Packaging2		<i>20 SEP 27 2018</i>
155	QC	6 pcs		7/16/18	0.00	0.00	QC5		<i>DAS 38</i>
180	Packaging	6 pcs		7/16/18	0.00	0.00	Packaging3-2 <i>CCK/2890</i>		<i>2 OCT 04 2018</i>
190	QC21-SA	6 Ea		7/16/18	0.00	0.00	QC21		<i>3-89</i>

Part Op 100 - Cut Blank at 7.250"

Descriptions: 110 - 1-Machine per folio FB192

140 - Issue P/O to ATG : *P0040983* 1- Black Anodize as per Dwg D4842

180 - ***IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER***

OCT 05 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet 1" Thick Plate X 5" Wide	3.6180 ft (.603 ea)	90-Start up Operation	

5104641

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	4	13	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

not be found.

Plex 5/28/18 7:20 AM Dart.lajeunesse.marie

Container No: S108744



Part: D4842-3

Job No: 178085

Serial No/Batch: S108744

Revision:

Inspector:

Exp Date:

Instructions:

Date: 09/10/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

DART AEROSPACE LTD		Work Order: 178085
Description: Lower Cutter Body, LH		Part Number: D4842-3
Inspection Dwg: D4842	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.13 x 45°	+/-0.030 x +/-0.5°	0.130 x 45	✓		Kt-05	Verm.
0.168	+0.003/-0.000	0.170	✓		Kt-01	Micrometre.
3.68	+/-0.030	3.68	✓		Kt-05	Verm.
0.43	+0.010/-0.000	0.437	✓		" "	" "
1.50	+/-0.030	1.500	✓		" "	" "
0.84	+/-0.030	0.843	✓		" "	" "
0.70	+/-0.030	0.700	✓		" "	" "
5.50	+/-0.030	5.500	✓		" "	" "
1.47	+/-0.030	1.470	✓		" "	" "
1.51	+/-0.030	1.510	✓		" "	" "
4.93	+/-0.030	4.93	✓		" "	" "
6.52	+/-0.030	6.520	✓		" "	" "
0.20	+/-0.030	0.200	✓		" "	" "
0.24	+/-0.030	0.250	✓		" "	" "
0.90	+/-0.030	0.900	✓		" "	" "
23.7°	+/-0.5°	23.7°	✓		CNC-17	A-G
6.8°	+/-0.5°	6.8°	✓		" "	" "
30.2°	+/-0.5°	30.2°	✓		" "	" "
0.360	+/-0.010	0.360	✓		Kt-05	Verm.
4.580	+/-0.010	4.580	✓		" "	" "
4.220	+/-0.005	4.220	✓		" "	" "
2.110	+/-0.005	2.110	✓		" "	" "
0.501	+/-0.010	0.501	✓		" "	" "
4.830	+/-0.010	4.830	✓		" "	" "
4.440	+/-0.005	4.440	✓		" "	" "
3.420	+/-0.005	3.420	✓		" "	" "
2.400	+/-0.005	2.400	✓		" "	" "
1.200	+/-0.005	1.200	✓		" "	" "
Ø0.177	+0.005/-0.001	0.177	✓		" "	" "
2.400	+/-0.005	2.400	✓		" "	" "
4.601	+/-0.010	4.601	✓		" "	" "
0.400	+/-0.010	0.400	✓		" "	" "

Measured by: KJ 1 9-89	Checked by: JL	QC Inspector:
Date: 2018-09-09	Date: 18-9-11	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
A	15.10.14	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040983**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO040983
PO Date: 9/11/18
Due Date: 10/5/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalonde, Marc-Andre

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178084	D4842-4	Lower Cutter Body, RH Issue P/O to ATG :	Firmed	-	10/5/18	6 pcs	0 pcs	6 pcs	\$11.10/pcs	\$66.60
					6X	SEP 27 2018					
2	178085	D4842-3	Lower Cutter Body, LH Issue P/O to ATG : 1- Black Anodize as per Dwg D4842	Firmed	-	10/5/18	6 pcs	0 pcs	6 pcs	\$11.10/pcs	\$66.60
					6X	SEP 27 2018					
3	182247	647.7912	Clip ISSUE P/O: Hard Anodize, Color Black and Prime As Per Dwg. 647.7900	Firmed	-	10/5/18	56 pcs	0 pcs	56 pcs	\$10.45/pcs	\$585.20
4	181356	647.1613	Doubler Issue P/O to ATG : 1- Black Anodize as per Dwg, SEE NOTE #3 2- PRIME AS PER DWG, SEE NOTE #3 Certification of Conformity is required	Firmed	-	10/5/18	40 pcs	0 pcs	40 pcs	\$8.75/pcs	\$350.00
					40X	SEP 27 2018					
5	181374	647.7918	Bracket ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG. (SEE NOTE 2)	Firmed	-	10/5/18	30 pcs	0 pcs	30 pcs	\$11.75/pcs	\$352.50
6	179154	646.3310	LH Half - Upper Cutter Assembly Issue P/O to ATG : 1- Black Anodize as per Dwg 646.3300	Firmed	-	10/5/18	16 pcs	0 pcs	16 pcs	\$18.95/pcs	\$303.20

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9/17/2018

PURCHASE ORDER



Dart Aerospace Ltd.
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Canada

PURCHASE ORDER

PO040983

Tel (613) 632-5200 —

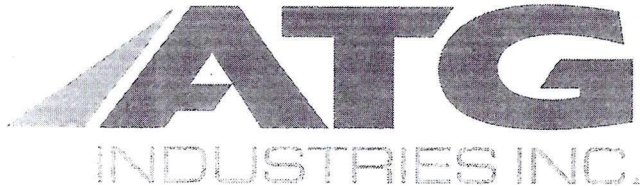
Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
7	179155	646.3311	RH Half - Upper Cutter Assembly Issue P/O to ATG :	Firmed	-	10/5/18	16 pcs	0 pcs	16 pcs	\$18.95/pcs	\$303.20
8	178573	RBT400213-1	Tab Bender Body -Issue P/O to ATG : PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Certificate of Conformity is required	Firmed	-	10/5/18	12 pcs	0 pcs	12 pcs	\$13.35/pcs	\$160.20
Grand Total:											\$2,187.50

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/17/18 10:13 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916129

Date: 26-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

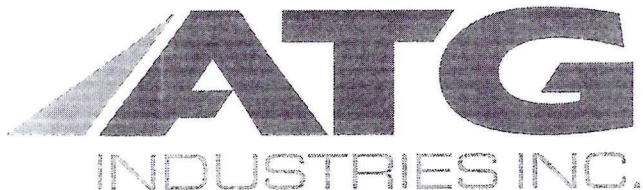
Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 6 ea	Part: D4842-4 ✓ Lower Cutter Body, RH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23732	Rev: B PO: PO040983 ✓ Line: 1	
✓ 6 ea	Part: D4842-3 ✓ Lower Cutter Body, LH Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23733	Rev: B PO: PO040983 ✓ Line: 2	
✓ 40 ea	Part: 647.1613 ✓ Doubler Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 23735	Rev: A PO: PO040983 ✓ Line: 4	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>26/09/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of Made in Canada.			

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A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916129

Date: 26-Sep-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms

Ship Via

ATG Delivery

Quantity

Description

receipt.

Made in Canada.